

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021949**Date Inspected:** 13-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhu Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: 13AW

PCMK: SEG3013H-048,049

Welder: 045143

WPS-B-T-2133-ESAB

PCMK: SEG3013R-006

Welder: 066421

WPS-B-T-2232-ESAB

Components: 13CW

PCMK: SA3232B-011

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Welder: 048696
WPS-B-T-2233-ESAB

PCMK: SA3232B-018
Welder: 048433
WPS-B-T-2233-ESAB

Components: 14W
PCMK: SEG3020AJ-264,265
Welder: 051348
WPS-B-T-2233-ESAB

PCMK: SA3442-X5056C
Welder: 045175
Report: B-WR20293
WPS-345-FCAW-3G (3F)-ESAB-FCM-repair

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shield Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Zhu Lin.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector

Components: 13AW
PCMK: SEG3013J-006
Welder: 047264
WPS-B-P-2213-TC-U4b-FCM-1

PCMK: SEG3013-001-009
Welder: 067829
WPS-B-P-2214-B-U2-FCM-1

Components: Deck Panel
PCMK: DP3138-001-001,002
Welder: 066398
WPS-B-T-4112-1

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; Anchor plate bearing block on item number 15, 16, 20, 23, 30 of NWIT tracker document # 08537,

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
